

SPA 864

CATEGORY	Metal spray wires
TYPE	High-alloyed tubular wire on a C-Ni-B- carbide basis for extreme hard deposits on parts subject to strong mineral abrasion.
APPLICATIONS	Cement industry, pumps, mixer blades, sleeves, mixers, shear blades and parts etc...
PROPERTIES	High wear resistance and simimilar structure as by C.-Cr. Carbide deposits. The deposit gives a very good hardness, all spray metal requires no buffer layer except on materials considered critical. In this Situation Ceweld SP NiAl is recommended. Suited for wear parts subject to extreme heavy abrasion. The spray deposit is only machinable by grinding.

CLASSIFICATION EN ISO 14700: TFE-13

SUITABLE FOR High-alloyed tubular wire for metal spray on a C-Ni-B- carbide basis for extreme hard deposits on parts subject to strong mineral abrasion. applications: Cement industry, pumps, mixer blades, sleeves, mixers, shear blades and parts etc.

APPROVALS CE approved

WELDING POSITIONS:



C	Mn	Si	Cr	Ni	B
0.30	1.10	0.40	0.30	1.50	1.40

MECHANICAL PROPERTIES

Heat Treatment	Bonding strength ASTM C633	Rm (N/mm ²)	A5 (%)	Impact Energy (J) ISO-V			Hardness HRc
				-20°C	-40°C	-60°C	
as sprayed							55-65

SPRAY PARAMETERS / PACKING

Spray Parameters			Packing	
D (mm)	Voltage (V)	Current (A)	Spools type	kg / spool
1.6	32	100-200	K-300	16
2.4	34	150-280	K-300	16
3.2	36	220-400	K-415	25

REDRYING TEMPERATURE not required